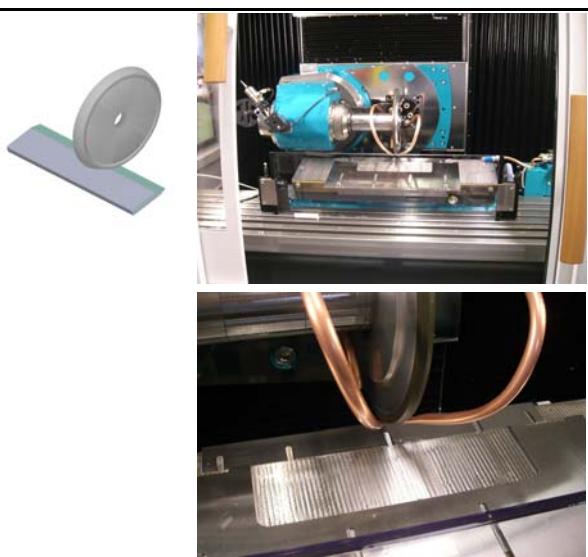


Flat Paper Knife L 400 mm, Z160

A24-010

High efficiency grinding of Paper Knives of 2 mm thickness in automatic loading works with an optimized strong magnetic table and in combination with dressing and sufficient coolant oil pressure. Process security is guaranteed by integration of additional cleaning operations. The multifunctional Fanuc Robot and a special stackdesign allows an autonomy of up to 24 hours.



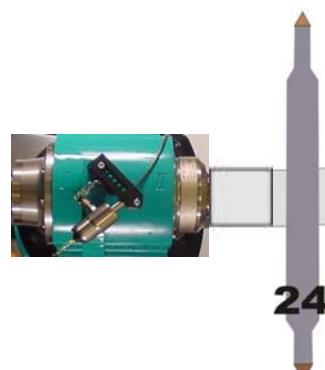
1. Cycletime for Production

Tool specifications			
Length 400 mm, Z160, tooth length 30 mm			
Material HSS			
Operations			
Feed [mm/Min]	2000	350	120
Power [kW]		4	1
Cutting feed [m/s]		35	12
Used wheels		24	24
Grinding time [s]	20	1219	42
Total cycle time	21 Min 20		

The mentioned cycle times are indicative. The material to be ground, different grinding wheels or other coolants can influence the cycle times considerably.

2. Used Grinding Wheels

24 Ø250 14V1 B126 V80°



3. Machine and Software Requirements

Machines: 5 axes CNC grinders : CORVUS GDS 650, Dressing, STL652
Control: Fanuc 160i
Coolant: Synthetic Oil, pressure 12 - 18 bar
Software: Quinto 4.3, DXQ

responsible engineer: OP,12.2.08

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